

Work Order ID 111105

Thursday, January 09, 2014 11:30:08 AM

111105

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Item ID: PB67-43001-51 Accept *N900040100* Setup Start *NS1*
Revision ID: 2 Stop *NS2*
Item Name: Long T-Handle Assembly
Start Date: 1/8/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 1/8/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: mf Date: 14-01-09 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-51	C

100 Weld per dwg A/R Aluminum rod Batch: 123928 0.00
Large Fab

1100

Large Fab

Memo

0.00

Large Fab

1- drill #40 hole in center of -91 before welding -93 caps, to let air out
2- weld -93 to -91 as per dwg
3- grind weld flush
4- assemble -87 under the pilot hole in -91 and weld as per dwg

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

1110

QC

Memo

0.00

Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00

1120

QC

Memo

0.00

Quality Control

CPC 13-01-30 2 @ 14-01-20 DAS 9 9-89

CPC 14-01-30 2 @ 14-01-20 DAS 9 9-89

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Item ID: PB67-43001-51 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long T-Handle Assembly
 Start Date: 1/8/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/8/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					2	0		<i>h</i>
Small Fab	Memo	0.00							14-01-17
Small Fab	1- line drill -89 and -87 using existing pilot hole of -87 as per dwg 2- install spring pin								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						①	14.920		DAS 9 9-89
QC	Memo	0.00							
Quality Control									
150	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
150	<i>M1111277</i>					2	φ	14-2-3	DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	***mask prior to powder coat per dwg*** START TIME: <i>11:55</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:05</i>								

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Item ID: PB67-43001-51

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Long T-Handle Assembly

Start Date: 1/8/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/8/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>Mezz 2</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

2

2x DAS 28 0.00 14-02-3

MCS 14-02-04

(M) 14-02-04

Picklist Print

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Work Order ID: 111105

Parent Item: PB67-43001-51

Start Date: 1/8/2014

Required Date: 1/8/2014

Parent Item Name: Long T-Handle Assembly

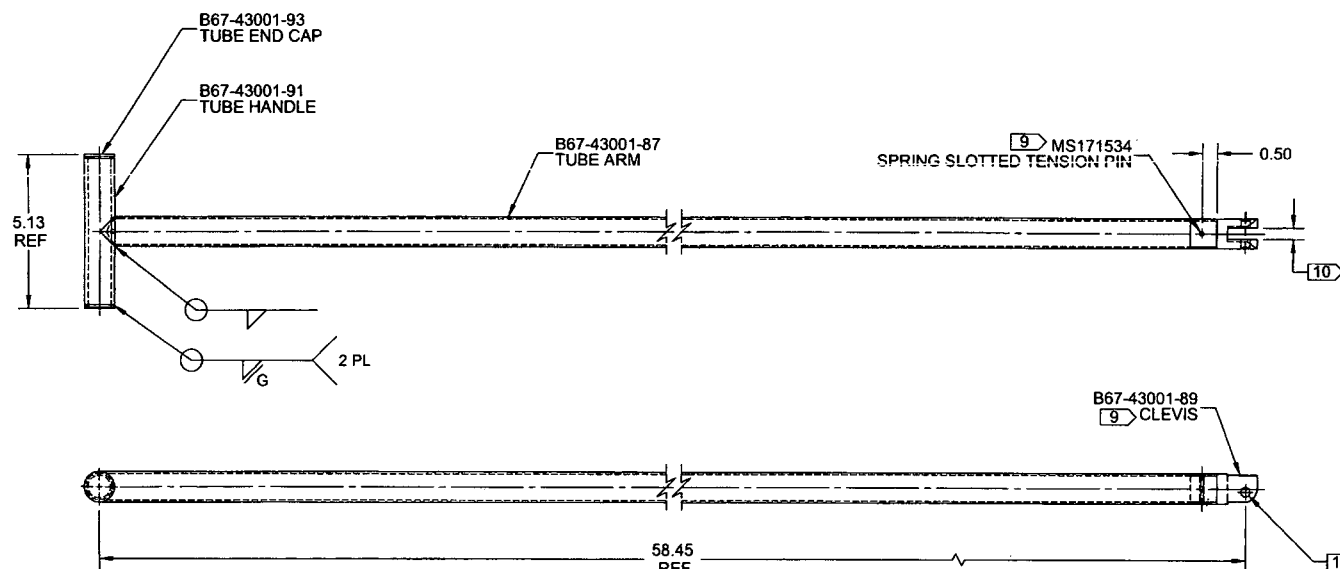
Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-87 Tube Arm		Manufactured	No			100	Each	2.0000	1	1		1/14.01.17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		2				2			
				100020		2							
PB67-43001-91 Tube Handle		Manufactured	No			100	Each	5.0000	1	1		1/14.01.17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		5				2			
				100017		5							
* PB67-43001-93 Tube End Cap		Manufactured	No			100	Each	6.0000	2	2		1/14.01.17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		6				2			
				41520		6							
240-107 SPRING SLOTTED PIN		Purchased	No			130	Each	16.0000	1	1		1/14.01.17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST382	3115827	16				2			
				124060		16							
PB67-43001-89 Clevis		Manufactured	No			130	Each	9.0000	1	1		1/14.01.17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		9				2			
				100018		9							

ITEM	QTY -19	P/N	DESCRIPTION
1	X	B67-43001-51	LONG T-HANDLE ASSY
3	1	B67-43001-87	TUBE ARM
4	1	B67-43001-89	CLEVIS
5	1	B67-43001-91	TUBE HANDLE
6	2	B67-43001-93	TUBE END CAP
8	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



B67-43001-51 LONG T-HANDLE ASSY

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.35 lbs
- 8) WELDING: PER QSI 004
- 9) PRIOR TO POWDER COAT, ALIGN B67-43001-89 ON B67-43001-87 AS SHOWN AND DRILL A $\varnothing 0.129$ HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-89 TO B67-43001-87 USING MS171534 SPRING SLOTTED PIN
- 10) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	ADS		
CHECKED	ADS		
MFG. APPR.	ADS		
APPROVED	ADS		
DE APPR.	N/A		
DATE	09.06.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **B67-43001-51**
TITLE **LONG T-HANDLE ASSY**
REV. C
SHEET 1 OF 1
SCALE
NTS

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other